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मानक

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Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 11379 (1985): Wrenches for Retaining Screw for Milling
Arbor [PGD 5: Assembly Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

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“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard

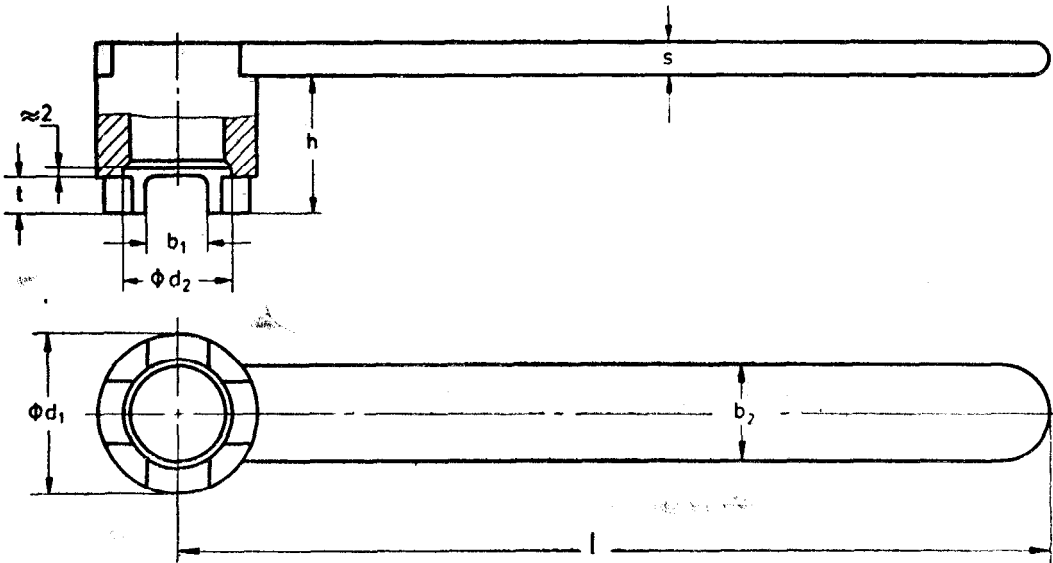
SPECIFICATION FOR
WRENCHES FOR RETAINING SCREW FOR MILLING ARBOR

1. **Scope** — This standard covers the requirements of wrenches for retaining screw for milling arbo used for tightening or loosening the retaining screws in accordance with IS : 8521-1977 'Retain ing screw for milling arbors'.
2. **Dimensions** — Shall be as given in Table 1.

TABLE 1 DIMENSIONS AND TORQUE REQUIREMENTS OF WRENCHES FOR
RETAINING SCREW FOR MILLING ARBOR

(Clauses 2 and 7.1)

All dimensions in millimetres.



Desig- nating Size*	b ₁		b ₂ ≈	d ₁	d ₂	h	l	s	t ±0.2	Torque Min Nm	Applicable for Retaining Screw Size
	Size	Tole- rance									
16	8.1	+ 0.1	12	22	15	20	180	5	6.2	55	M 8
22	10.1		16	28	19	25	200	6	7.2	95	M10
27	12.1		20	35	22	32	225	8	8.5	135	M12
32	16.1	+ 0.15	25	42	28	36	250	8	9.5	275	M16
40	20.2		30	52	35	40	280	8	11	520	M20
50	24.2	+ 0.2	30	63	41	45	315	8	13	830	M24
60	28.2		35	76	51	50	355	10	15	1 500	M30

Note — For retaining screws, see IS : 8621-1977.

*The designating size corresponds to the diameter of the arbors.

3. Material — Shall be any suitable steel, meeting the requirements laid down in 5 and 7.

Suitable Example :

T50Cr 4V 23 of IS : 3749-1978 'Tool and die steels for cold work (*first revision*)'.

15Ni 2Cr 1Mo 15 and 17 Mn 1Cr 95 of IS : 4432-1967 'Case hardening steels'.

4. Manufacture, Workmanship and Finish

4.1 The wrenches shall be neatly forged, fabricated or machined; and shall be free from cracks, seams, burrs, scales and other surface as well as manufacturing defects.

4.1.1 The sharp edges of the handle shall be rounded off so as to have an easy grip.

4.2 The wrenches may be given suitable anticorrosive coating to avoid rust.

5. Hardness

For Wrenches, Sizes 16 to 32 *40 HRC Min*

For Wrenches, Sizes 40 to 60 *35 HRC Min*

6. Designation — Wrench of designating size 22, used for retaining screw of size M10, shall be designated as :

Wrench 22 — M10 IS : 11379.

7. Test

7.1 Torque Test — Wrenches shall meet the test torque values specified in Table 1.

7.2 Crack Detection Test — If desired by the purchaser; the wrenches fabricated by welding may be tested for detecting crack in accordance with IS : 5334-1981 'Code of practice for magnetic particle flaw detection of welds (*first revision*)' or IS : 4260-1976 'Recommended practice for ultrasonic testing of welds in ferritic steel (*first revision*)'.

8. Marking

8.1 Wrenches shall be clearly marked/stamped with designation and the manufacturer's name, or recognized trade-mark.

8.2 ISI Certification Marking — Details available with the Indian Standards Institution.

9. Sampling — Shall be as specified in IS : 6131-1980 'Technical requirements for hand operated wrenches (spanners) and sockets (*first revision*)'.

EXPLANATORY NOTE

While preparing this specification, considerable assistance has been taken from DIN 6368 : 1962 Spanners for shell end mill arbors, issued by the Deutsche Institut für Normung.